

Work Order ID 64707

Tuesday, December 14, 2010 1:13:41 PM

Page 1

Item ID: D412-698-023

Accept

Revision ID:

Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2010 Start Qty: 4.00

Required Date: 12/22/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

S 10/12/20

10-12-20
(4)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/12/20
(40)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 10/12/20

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-698-023

Accept

Setup Start

Revision ID:

Stop

Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-023

Location:

PPP Rev:

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

D41260 SL (40)

10/12/2010
MF
10-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, December 14, 2010 1:13:45 PM

Page 1

Work Order ID: 64707

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S ₄ AN960JD516L Washer	NAS1149D0516J	Purchased	No			120	Each	81.0000	2	8 10/12/10		sf	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		81							
					112466	81							
S ₄ D3552-11 Door Prop		Manufactured	No			120	Each	11.0000	4	4 10/12/10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272		11							
					58967	1							
					63927	10							
S ₄ D3594-043 Floor Doubler Assembly, LH		Manufactured	No			120	Each	16.0000	1	4 10/13/10		sf (40)	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST234B		16							
					53712	4							
					54838	2							
					64084	10							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 64707

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

D3594-044

Manufactured No

120

Each

15.0000

1

4



Floor Doubler Assembly, RH

Location

Loc Qty

Loc Code

ST

5

57746

5

ST234B

10

64085

10

D3594-5

Manufactured No

120

Each

22.0000

1

4



Door Doubler

Location

Loc Qty

Loc Code

ST234A

22

58968

8

64086

14

D3622-1

Manufactured No

120

Each

23.0000

2

8



Ball Stud

Location

Loc Qty

Loc Code

ST070

20

63928

20

ST074

3

62474

3

MS20426AD4-4

Purchased No

120

Each

3,397.000

2

8



Rivet

Location

Loc Qty

Loc Code

ST316

367

15541

367

ST317

3030

116188

3030

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 64707



Parent Item: D412-698-023



Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 4.00

Required Qty: 4.00

MS21073L5

Purchased

No

120

Each

74.0000



4
10/12/10

SP 40

nut plate

Location

Loc Qty

Loc Code

ST303

74

113660

74

Y

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01